

3hp 10/03

Work Order ID 67156

Wednesday, March 09, 2011 11:32:54 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4165-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Doubler

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	PA1								
100		0.00							
Waterjet									
FLOW CNC Waterjet									
2024.040									
	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: PA1								
	Prog Rev: PA1								
	2-Deburr if necessary								
110		0.00							
QC									
Quality Control									
	Memo	0.00							
	QC2- Inspect parts off machine FAI/FAIB								

B11-3-9

①

B11-3-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67156

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Page 2

Item ID: D4165-1

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Setup Start



Revision ID: PRELIM

Stop



Item Name: Doubler

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to part



QC

Memo

0.00

Quality Control

Day only
8/10/10

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-3-10

135

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/3/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Work Order ID 67156

Wednesday, March 09, 2011 11:32:54 AM

Page 3

Item ID: D4165-1

Accept

Revision ID: PRELIM

Item Name: Doubler

Start Date: 3/9/2011 Start Qty: 1.00

Required Date: 3/10/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/3/10

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

~~11/3/10~~
Roberto

U 1103-10

POSITIVE RECALL

EFFECTIVE 11-03-09 AUTH _____

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 11:32:51 AM

Page 1

Work Order ID: 67156



Parent Item: D4165-1



Parent Item Name: Doubler

Start Date: 3/9/2011

Required Date: 3/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	184.0595	0.353	0.371579			



2024-T3 .040 sheet



11-3-9

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	11.8	
114415	11.8	
MAT22	172.2595	
110305	21.93	
111786	7.66	
112291	14.25	
112331	52	
113162	76.4195	

110305

(1)

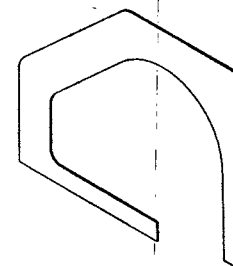
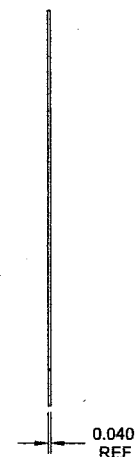
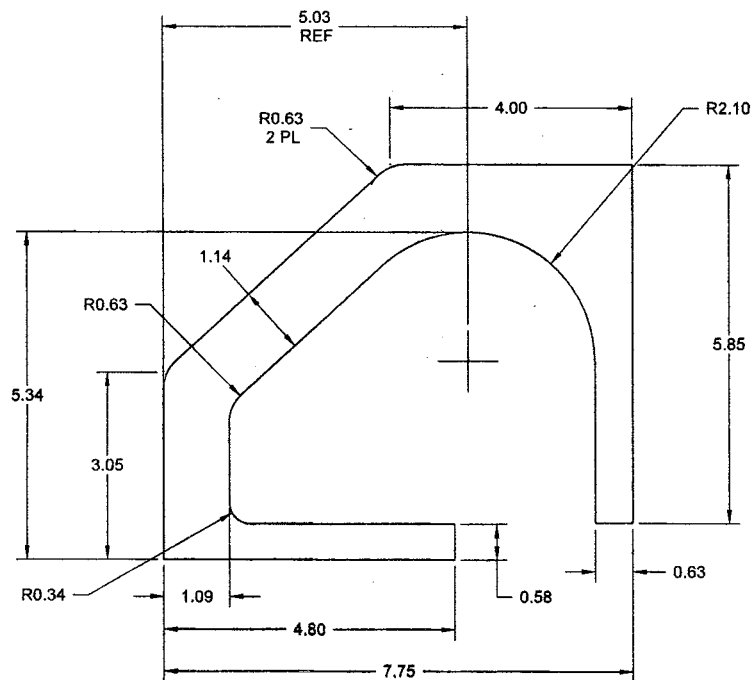
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NOTE: Date & initial all entries



D4165-1 DOUBLER

PRELIMINARY ISSUE

10.11.22

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

4067156

PA1	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.		D4165	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
DATE	10.11.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

